

Work Order ID 149154

Tuesday, July 19, 2016 2:40:30 PM

149154

Page 1

Item ID: D4653-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 7/11/2016 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 7/19/2016 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21** Date: **JUL 20 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4653	A

100		0.00				24	Ø		DAS 20 9-89 16-07-26
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK AT 3.025"								

110		0.08				24	Ø		DAS 20 9-89 16-07-29
110									
HAAS 1	Memo	0.64							
HAAS CNC vertical machine #1	MACHINE AS PER DWG & FOLIO FB119 FOLIO REV: <u>AA</u> DWG REV: <u>A</u>								

DEBURR

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY					
Environment	☐	☐ No Re-verification	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐ Positioned Wrong
Design	☐	☐ Operator	Bending	☐	Set-up	☐	Folio/Program	☐ Outside Dimensions
Doc/Data	☐	☐ Offset/Setup	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐ Over/Under tolerance
Equip/Tooling	☐	☐ Supplier	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐ Part Incorrect
Handling/Pre	☐	☐ Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐	☐ Use for Testing	Cuffs	☐	Contamination	☐	Out of Sequence	☐ Part Moved
Internal Transport	☐	☐ Poor Information	Crushing	☐	Countersink	☐	Off-set	☐ Drawing
Tribal Knowledge	☐	☐ Rushing	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐ Finish
LOA	☐	☐ Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐ Misread
Substation	☐	☐ Process Improvement	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐ Turning Sequence
Past Expiry Date	☐	☐ Manufacturing Process	OTHER : _____					
Misidentified	☐	☐ Past Due						

Work Order ID 149154

Tuesday, July 19, 2016 2:40:30 PM

149154

Page 2

Item ID: D4653-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 7/11/2016 Start Qty: 24.00

24

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.04

Quality Control

24

0

DAS

20

9-89

16-07-29

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.08

Quality Control

2167-30

140

Identify as per dwg & Stock Location: ST224

0.00

140

Packaging

Memo

0.04

Packaging

DAS
6
9-89

PC

AUG 02 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐ _____					

Work Order ID 149154

Tuesday, July 19, 2016 2:40:30 PM

149154

Page 3

Item ID: D4653-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 7/11/2016 Start Qty: 24.00

24

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89	AUG 0 4 2016	
150									
QC	Memo	0.40							
Quality Control									

DAS
21
~~9-89~~

AUG 0 2 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, July 19, 2016 2:40:30 PM

Page 1

Work Order ID: 149154

149154

Parent Item: D4653-11

D4653-11

Parent Item Name: Clamp

Start Date: 7/11/2016

Required Date: 7/19/2016

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 12/06/12 NEW ISSUE JFS VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINB1.000X04.0 00		Purchased	No			100	f	13.5250	0.252	6.366316			

MDFI RINB1 000X04 000

Delrin Bar

6.333'

DAS
20
9-89

16-0726

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT011	13.525	
m133488	13.525	

6.333'

DQA: _____ Date: _____



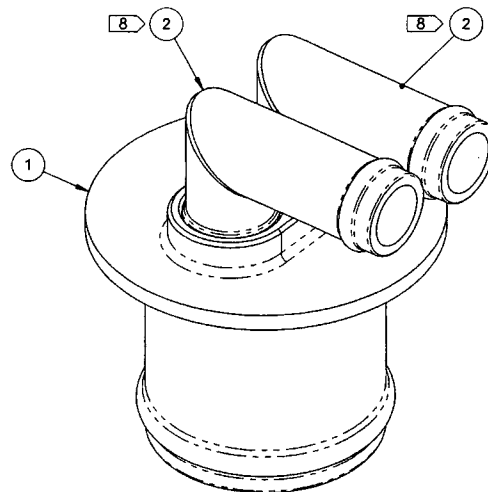
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

ITEM	QTY	P/N	DESCRIPTION
	X	D4653-041	VENT MANIFOLD ASSEMBLY
1	1	D4653-3	COLLAR
2	2	D4653-045	FITTING ASSEMBLY
3	A/R	LUBRICANT	MOLKOYE 55 O-RING GREASE



D4653-041 VENT MANIFOLD ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149154 MJS

16-07-20

RELEASED
2012-11-05
MB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.35 lbs
- 8) APPLY A LAYER OF MOLYKOTE 55 O-RING GREASE TO O-RING PRIOR TO INSTALLING D4653-045

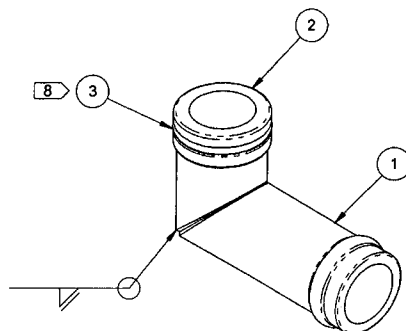
A	NEW ISSUE	MB	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DF</i>		
DRAWN	<i>AB</i>		
CHECKED	<i>AB</i>		
MFG. APPR.	<i>AV</i>		
APPROVED	<i>MB</i>		
DE APPR.	<i>MB</i>		
DATE	12.07.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4653** REV. A
SHEET 1 OF 6
TITLE **VENT MANIFOLD ASSY** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4653-045	FITTING ASSEMBLY
1	1	D4653-7	LARGE FITTING
2	1	D4653-9	SMALL FITTING
3	1	D4654-3	O-RING



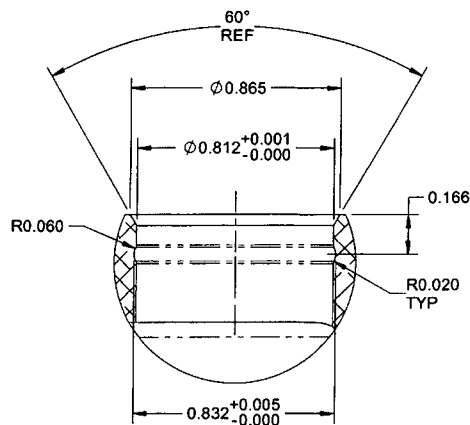
D4653-045 FITTING ASSEMBLY

RELEASED
2012-11-05
MP

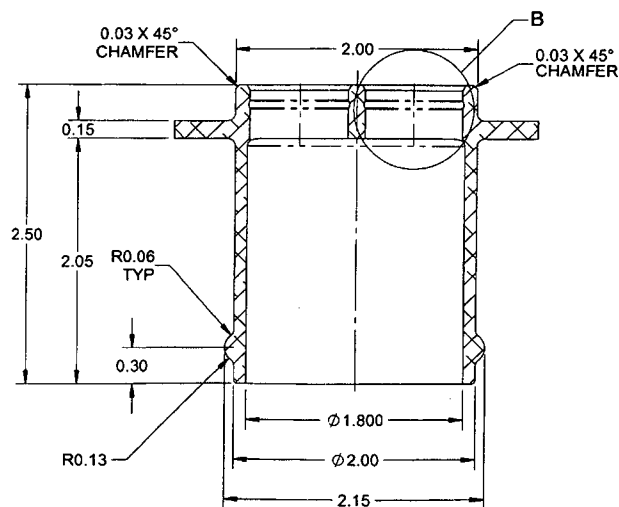
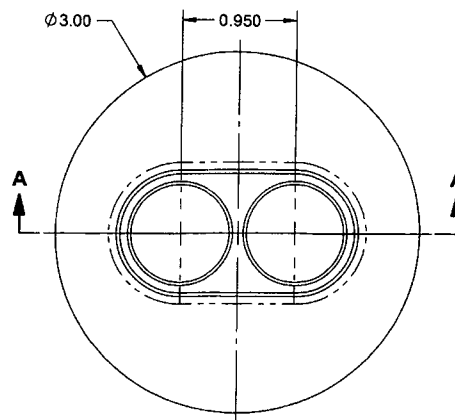
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD PER QSI 004
- 9) CHEMICAL CONVERSION COAT PRIOR TO INSTALLING O-RING

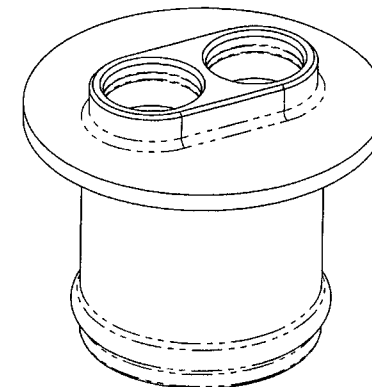
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4653	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VENT MANIFOLD ASSY	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION B-B
SCALE 2X, 2 PL



SECTION A-A



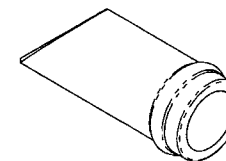
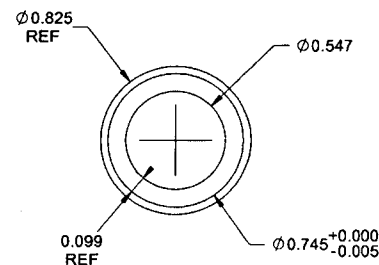
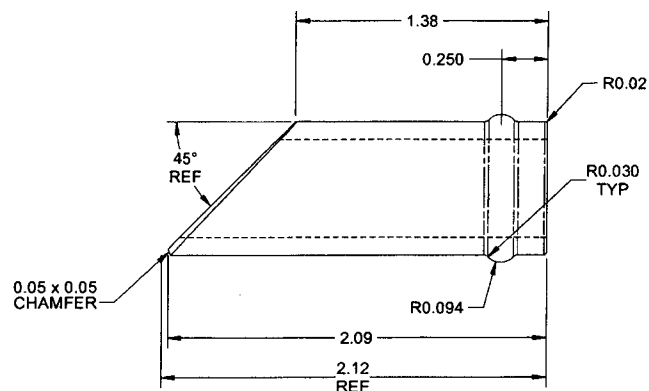
D4653-3 COLLAR

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

RELEASED
2012-11-05

DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE		
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	D4653	SHEET 3 OF 6
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	VENT MANIFOLD ASSY	NTS
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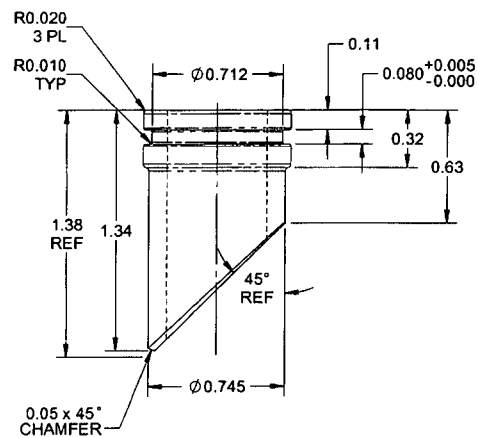
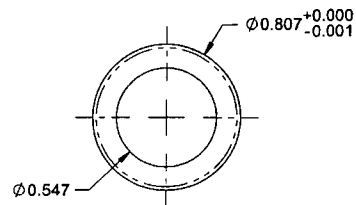
D4653-7 LARGE FITTING

NOTES:

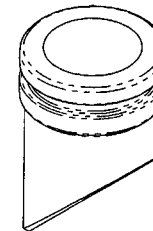
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>DF</i>	DART AEROSPACE LTD	
DRAWN	<i>DF</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AV</i>	D4653	SHEET 4 OF 6
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	VENT MANIFOLD ASSY	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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RELEASED
2012-11-05
JMO



D4653-9 SMALL FITTING

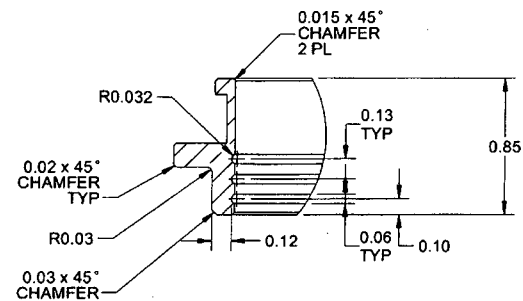
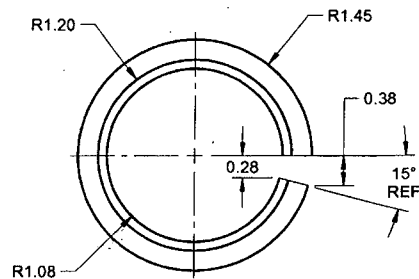


RELEASED
2012-11-05
JMP

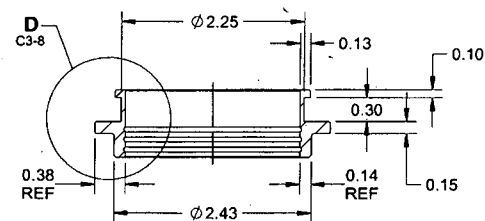
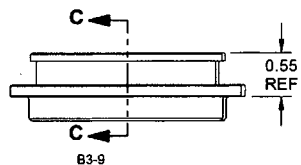
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4653	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VENT MANIFOLD ASSY	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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DETAIL D C4-9
SCALE 2X



SECTION C-C C6-9

D4653-11 CLAMP

RELEASED
2012-11-05
NW

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.032 lbs

DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE	DRAWING NO.	REV. A
CHECKED	JE	D4653	SHEET 6 OF 6
MFG. APPR.	JE	TITLE	SCALE
APPROVED	JE	VENT MANIFOLD ASSY	NTS
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DATE	12.07.25		